



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.1702

Job Sheet 213424



Part No: 647.1702

Job Qty: 6 pcs

DAS
21
9-89

Part Name: Skid Deflector Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/25/20

Job Tracking No:

Due Date: 10/9/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: 647.1700 REV.F IPP REV:A NEW ISSUE 13.07.17 JLM VERIFIED BY:DD IPP REV:B 14.09.26 AS PER DWG
C1 DD VERF:JLM IPP REV:C 20.07.07 AS PER DWG REV.F DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Small Fab - 1	9 pcs.	10/9/20		0.00	13.50	Small Fab - 1		DAS 58 9-89 OCT 06 2020 OCT 08 2020
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
							Small Fab - 9		
							Small Fab - Various 1		
130	QC 5	9 pcs	10/9/20		0.00	0.00	QC 5 - 10		DAS 81 9-89 OCT 08 2020
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
							QC 5 - 82		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S305685



Part: 647.1702

Job No: 213424

Serial No/Batch: S305685

Revision: REV.F

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/08/20

Plex 9/25/20 12:43 PM Dart.lajeunesse.marie

210 Packaging 3-1 - Stock - B4B 9 pcs

10/9/20

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B ✓

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

Packaging 3 - 37 - B4B

DAS

OCT 09 2020

80

CCK038

9-89

220 QC 21 - SA

9 pcs

10/9/20

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 9

QC 21 - SA - 77

QC 21 - SA - 28

DAS

21 OCT 09 2020

9-89

Part Op 120 - 1- Assemble item 4,6,7 and 8 as per dwg. 2- Clamp item 1 and 2 to item 3. Transfer drill holes as per dwg see note
 Descriptions: 6. Use clecos. 3- Disassemble parts 4- Deburr 5- Touch up expose aluminum with alodine *** TOUCH UP RIVET WITH
 PRIMER *** PRIMER BATCH: S26577R *** 6- Re-assemble as per dwg

130 - (QC5- Inspect part completeness to step on W/O)

210 - (Identify as per dwg & Stock Location: _____), ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

220 - (QC21- Final Inspection - Work Order Release)

017675

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
647.1712 031	Gusset	9 pcs (1 ea)	120-Small Fab - 1	S290466
647.1713 107	Spacer	9 pcs (1 ea)	120-Small Fab - 1	S246087
647.1714 44	Plate	9 pcs (1 ea)	120-Small Fab - 1	S28584
647.1715 44	Plate	9 pcs (1 ea)	120-Small Fab - 1	S28584
CR3213-4-04	Rivet, Cherry	198 Ea (22 ea)	120-Small Fab - 1	S292589
MS21042L3-3T 303	Nut	9 Ea (1 ea)	120-Small Fab - 1	S299967
MS27039-1-14 CA016	Screw	9 Ea (1 ea)	120-Small Fab - 1	S160000
NAS1149F0332PSTX2	Washer (AN960-10L)	18 Ea (2 ea)	120-Small Fab - 1	S297630

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-Small Fab - 1	647.1712	9	29	0
	647.1713	9	30	0
	647.1714	9	19	0
	647.1715	9	9	0
	CR3213-4-4	198	92	0
	MS21042L3	9	1,053	0
	MS27039-1-14	9	346	0
	NAS1149F0332P	18	2,014	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					